

AMENDMENT NO. 1 OCTOBER 2023

TO

IS 6719 : 1972 SPECIFICATIONS FOR SOLID PVC SOLES AND HEELS

(*Cover page, Title*) — Substitute the following for the existing:

‘MOULDED PVC UNIT OUTSOLES — SPECIFICATION’

(*Page 1, Title*) — Substitute the following for the existing:

‘MOULDED PVC UNIT OUTSOLES — SPECIFICATION’

(*Page 3, clause 1.1*) — Substitute the following for the existing:

‘This standard prescribes the requirements and the methods of sampling and test for moulded PVC unit outsoles.’

(*Page 3, clause 1.1.1*) — Delete.

(*Page 3, clause 1.1.2*) — Substitute the following for the existing:

‘Top-lifts and ladies high heel (heels with heel height above 50 mm) are not covered in this standard.’

(*Page 4, clause 3.2*) — Substitute the following for the existing:

‘The outsole shall have antislip design, or any other suitable design as agreed to between the purchaser and manufacturer.’

(*Page 4, clause 3.3*) — Delete.

(*Page 4, clause 3.5*) — Substitute the following for the existing:

‘The outsoles manufactured in accordance with this standard may be made in all sizes as per IS 1638.’

(*Page 4, clause 3.5.1*) — Delete.

(*Page 4, clause 3.6, Table 1*) — Substitute the following for the existing table:

Table 1 Requirements for Moulded PVC Unit Outsoles
(*Clause 3.6*)

SI No.	Characteristics	Requirement	Method of Test, Ref to	
			Annex	IS
(1)	(2)	(3)	(4)	(5)
i)	Relative density, <i>Max</i>	1.3	—	Annex C-1 of IS 10702 : 2023
ii)	Hardness, degree Shore A	50 to 85	—	IS 12240 (Part 2) : 1988
iii)	Volatility, percent by mass, <i>Max</i>	1.0	A-4	—

Price Group 2

Table 1 (Concluded)

SI No.	Characteristics	Requirement	Method of Test, Ref to	
			Annex	IS
(1)	(2)	(3)	(4)	(5)
iv)	Lead (as Pb), ppm, <i>Max</i>	2.0	-	IS 12240 (Part 5) : 1988
	(a) Standard english sizes as per IS 1638 for infants, children's, and boys' and girls'			
	(b) For other sizes as per IS 1638	6.0 (see Note)		
v)	Flexing resistance, Bennewart method, cut growth at the end of 30 000 cycles, mm, <i>Max</i>	6.0	-	Annex D of IS 15844 (Part 1) : 2023
vi)	Abrasion resistance at applied force of 10 N (volume loss), mm ³ , <i>Max</i>	350	-	IS 3400 (Part 3) : 2021
vii)	Thickness, mm, <i>Min</i>	2.0	-	IS 12240 (Part 1) : 1988
viii)	Tear strength (average force), kN/m, <i>Min</i>	5.0	-	Method A of IS 3400 (Part 12) : 2022

NOTE — This limit shall be applicable if recycled PVC is used in the manufacturing of sole and shall be in force till 31 December 2024, after which this shall be withdrawn and limit of 2.0 ppm shall be applicable for all sizes.

(Page 5, clause 3.6.1) — Delete.

(Page 5, clause 4) — Substitute the following for the existing:

‘4 PACKING AND MARKING

4.1 Packing

The soles may be packed as agreed to between the purchaser and the supplier. Each package shall contain soles of same size only and may be marked with the name of the item, batch/code number, size, and manufacturer's name or its recognized trade-mark, if any.

4.2 Marking

4.2.1 Each sole shall be marked legibly and indelibly with the following:

- a) Identification of source of the manufacturer or brand name, if any;
- b) Size of the footwear for which it is intended; and
- c) ‘Made with recycled PVC’ (This shall be marked if recycled PVC is used in the manufacturing of the outsoles).

4.2.2 BIS Certification Marking

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the products may be marked with the Standard Mark.’

(Page 5, 6, clause **6, 6.1, 6.2, 6.3 and 6.4**) — Delete.

(Page 6, 7, 8, 9, 10, 11, 12 and 13, Appendix A) — Delete **A-1, A-2, A-3, A-5, and A-6**.

(Page 12, clause **A-4.2**, First line) — Substitute the following for the existing:

‘Disc of 57 mm diameter shall be cut from the test slab made of the same composition of material and cured under identical condition and shall be provided by the supplier.’